

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008268**Date Inspected:** 03-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Du Zhi Qun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector, George Goulet, also randomly observed the following work in progress in Bay 10:

FCAW welding, using northwest gantry, of weld joint NSD1-FCSA4-1B/C-2, 3 located on north tower, lift 4, skin C. Welders were identified respectively as 053116, 057244. ZPMC QC was identified as CWI Du Zhi Qun (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-2332-Tc-P5-F.

SMAW tack welding of vertical weld joint on part ED1-A6003-1, weld designation unknown to QC1 located on east tower. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-4113.

FCAW welding of weld joint SSTL3-1B/K-81B located on south tower shaft, lift 3. Welders were identified respectively near midbottom and midtop as 050041, 052075. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Wang Hao, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2232-C-U2-F.

SAW welding of weld joints ND1-A713C/E-85 located on PCMK north tower. Welder was identified as 201750.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC QC Inspector Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC1 and QC1's assistant appeared to comply with WPS-B-T-2221-L3c-S-2.

OBG Trial Assembly Area

This QA Inspector, George Goulet, received ZPMC X-RAY NON-DESTRUCTIVE TEST NDT NOTIFICATION for the Trail Assembly Area to be performed beginning 3Aug@2200hrs and ZPMC notification of witness inspection #3829 for MT inspection scheduled for 2200 hours, also this day, in OBG Trial Assembly Area. At 2150 hours, this QA Inspector, George Goulet, asked ZPMC QA Inspector Wang Lu (QA) where, specifically, the above noted X-ray testing was to be performed. QA informed this QA Inspector, George Goulet, that the x-ray testing would be performed in OBG section 1AE and 1BE. This QA Inspector, George Goulet, went to the area and observed the safety boundaries for the X-ray testing being placed. This QA Inspector, George Goulet, did not proceed with the MT inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As noted above and this QA Inspector, George Goulet, asked QC monitoring the welding if all the welding variables observed by QC appeared to comply with the appropriate WPS, including the preheat requirements according to thickness of the thickest member being welded. QC monitoring the welding showed this QA Inspector, George Goulet, that QC was carrying the proper temperature sticks to monitor the minimum and maximum preheat and interpass temperatures and replied that all QC observed did appear to comply.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
